

V470 Varix Carbide Endmills

High efficiency machining

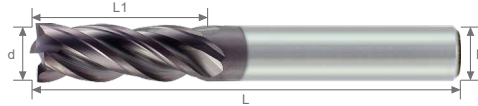
NEW

- *High removal rate machining for steel.*
- *Unequal Flute Spacing design.*
- *Outstanding Anti-vibrations design.*
- *Low cutting force and burr prevention.*



V470 Varix Carbide Endmills - Variable Spacing - 4F

EPSSV Series



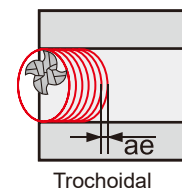
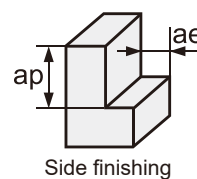
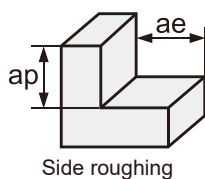
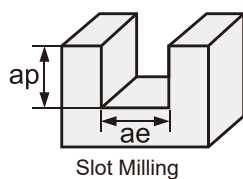
Work Material							
Carbon Steel (S45C, S55C)	Alloy Steel (SK, SCM)	Pre-Hardened Steel / Hardened Steel			Stainless Steel (SUS304, 306)	Cast Iron	Copper Alloy
		~ HRC 40	~ HRC 45	~ HRC 55			
◎	◎	◎	○	○	◎	◎	○

Order No.	Dia (d)	Flute Length (L1)	OAL (L)	Shank (D)	Flutes (F)
EPSFV404000U	4	10	50	4	4
EPSSV403000U	3	8	50	6	4
EPSSV404000U	4	10	50	6	4
EPSSV406000U	6	15	50	6	4
EPSSV408000U	8	20	60	8	4
EPSSV410000U	10	25	75	10	4
EPSSV412000U	12	30	75	12	4

Recommended Cutting Conditions

※If the machine not stable, please reduce the feed about 20%.

Working Material	Cutting Application	ae (mm)	ap (mm)	Vc (m/min)	fz (mm/z)				
					4mm	6mm	8mm	10mm	12mm
Carbon Steel (S45C)	Slot Milling	1×d	0.5 ~ 1.0×d	80 ~ 145	0.025	0.030	0.040	0.050	0.060
	Side roughing	0.4 ~ 0.9×d	0.7 ~ 1.0×d	90 ~ 160	0.030	0.035	0.050	0.060	0.075
	Side finishing	0.1 ~ 0.3×d	0.7 ~ 1.5×d	130 ~ 225	0.020	0.025	0.035	0.045	0.055
Carbon Steel (S50C)	Slot Milling	1×d	0.5 ~ 1.0×d	70 ~ 130	0.025	0.030	0.040	0.050	0.060
	Side roughing	0.4 ~ 0.9×d	0.7 ~ 1.0×d	80 ~ 145	0.030	0.035	0.050	0.060	0.075
	Side finishing	0.1 ~ 0.3×d	0.7 ~ 1.5×d	95 ~ 180	0.020	0.025	0.035	0.045	0.055
Tool Steel (SKD)	Slot Milling	1×d	0.5 ~ 1.0×d	65 ~ 110	0.020	0.025	0.035	0.045	0.055
	Side roughing	0.4 ~ 0.9×d	0.7 ~ 1.0×d	70 ~ 130	0.030	0.035	0.045	0.055	0.070
	Side finishing	0.1 ~ 0.3×d	0.7 ~ 1.5×d	90 ~ 160	0.020	0.025	0.035	0.040	0.050
Hardened Steel (HRC < 55)	Slot Milling	1×d	0.5 ~ 1.0×d	30 ~ 60	0.015	0.020	0.025	0.030	0.035
	Side roughing	0.4 ~ 0.9×d	0.7 ~ 1.0×d	50 ~ 90	0.015	0.020	0.030	0.035	0.040
	Side finishing	0.1 ~ 0.3×d	0.7 ~ 1.5×d	65 ~ 120	0.020	0.025	0.035	0.040	0.050
Stainless Steel (SUS304, SUS316)	Slot Milling	1×d	0.5 ~ 1.0×d	50 ~ 65	0.015	0.020	0.030	0.035	0.040
	Side roughing	0.4 ~ 0.9×d	0.7 ~ 1.0×d	65 ~ 100	0.020	0.025	0.035	0.045	0.055
	Side finishing	0.1 ~ 0.3×d	0.7 ~ 1.5×d	80 ~ 110	0.020	0.025	0.035	0.040	0.050



WINSTAR CUTTING TECHNOLOGIES CORP.

No. 10, Gongye 6th Road, Tainan Technology Industrial Park,
Tainan City 709, Taiwan

TEL : +886-6-3840386

FAX : +886-6-3840387

www.winstarcutting.com

info@winstarcutting.com

Dealer :

SILTECH ENGINEERING LLC

02099, м. Київ, ВУЛИЦЯ БОРИСПІЛЬСЬКА, 9

Тел.: +380 44 369 33 92

Факс: +380 44 369 33 92

info@siltech.com.ua | www.siltech.com.ua